

Work Order ID 164474

164474

Page 1

Wednesday, July 19, 2017 2:39:38 AM

Item ID: D2620 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube, 206 Skidtube
 Start Date: 8/1/2017 Start Qty: 300 ***A*** Cust Item ID:
 Required Date: 8/4/2017 Req'd Qty: 300 ***A*** Customer:
 Reference:

Approvals: Process Plan: 21 Date: JUL 20 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2620	Rev B

100	Skidtubes	0.69							
100									
Skidtubes	Memo	0.73							
Skidtubes	1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008								

2- Cut Fwd end of tube as per Dwg D2620

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.10							
Quality Control									

30 MGR 17/08/02
 S.D.T.
 BE
 30 0 1708-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 164474***164474***

Page 2

Wednesday, July 19, 2017 2:39:38 AM

Item ID: D2620 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube, 206 Skidtube
Start Date: 8/1/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>LG002</u>	0.00							
120									
Packaging	Memo	0.05							
Packaging	LOCATION : LG002								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.50							
Quality Control									

30 M64 17/08/02

17/8/9 48

AUG 03 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, July 19, 2017 2:39:41 AM

Page 1

Work Order ID: 164474

164474

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 8/1/2017

Required Date: 8/4/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-1-160

Manufactured

No

100

Each

82.0000

1

~~15~~ 30

D2600-1-160

**

30 MGG 12/08/02
DT.

Extrusion Round 3" 206

Location

Loc Qty

Loc Code

HALL

78

136919

9

141287

69

LG002

4

136919

4

7
~~30~~ 23

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

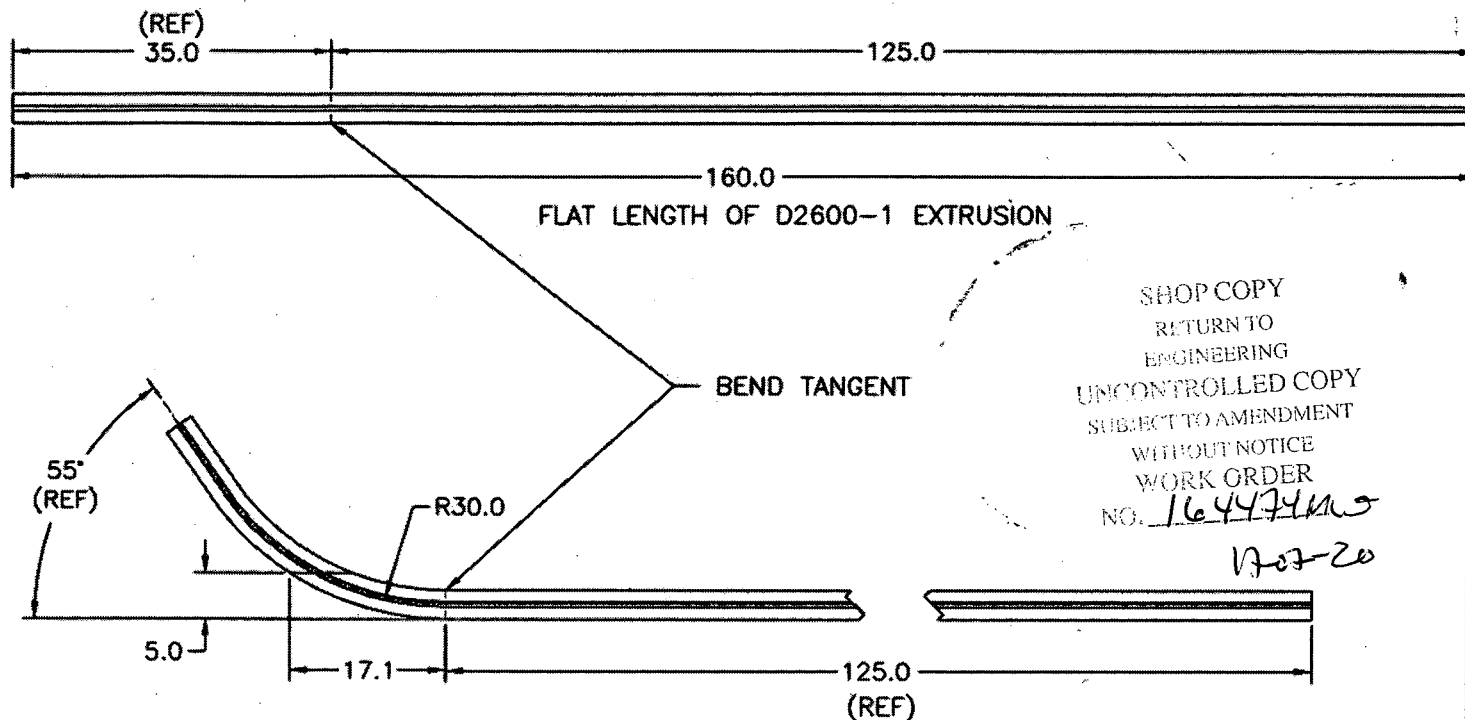
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SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164474119
12-20

RELEASED
99.09.15 DS

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
1	RF	FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO.
1	16	D2620
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	NEW ISSUE	SCALE 1:20
B	UPDATE FOR IN-HOUSE BENDING	